Work Order I October-23-12 3:14		44		*921	144*							Page 1
Revision ID:	12-702-07			Accept	*N900	040	100	*	Setup	Start Stop		S1*
	_	Shoulder Harness, 4 po								этор	*N	S2*
Required Date: 10/2	23/12 23/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Reference: Approvals: Pro	ocess Plai	n: ML5	Date: 12-10-24	Tooling:	Da	ate:	<u>. </u>		Run	Start	*N	R1*
QC	C:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center ID		Operation Description	\	Set Up/ Run Hours	Tool ID	Tool #		Accept Qty	t Rej		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										
DSI9612 IIN-D412-702-3	A A				SAS							
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DC Document Control		Memo Photocopy b	oluefile & type labels per PP	0.00 PD412-702-071 CHG0	SHOULD R	色の						10/11/28
110		Pick Kit		0.00	Str Oto							12/11/2
110 Packaging		Memo		0.00								12/11/2

Packaging

VCR:	Yes /	No	WORK ORDER NON-CONF

DQA:	Da	te;	 •	A '	_
				•	

NCR: Y	es /	No			WORK ORDER NON-	CON	IFORI	MANCE / UP	DATE			•
										QA Closed:	Dat	e:
Work Orde					DISPOSITION	Ì			AGAINST DE	PARTMENT,	/PROCESS	
Work Orde	er				Rework	7 I		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	No.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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	Bend	_			Bend	\vdash	Grain			Ovalized		Pressure/Forced
		re Not Cond	entric to	O/S	BOM/Route		Hardwa			Over/Under	1	Temperature/Cure
	Crac				Broken/Damaged		•	ion Incomplete		Part Incorre	1	Weld
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}	_	ection Strip les in Bend	ın tube	<u> </u>	Cut Too Short Drill Holes		Misread Offset	u		Power Loss/	ourge	Other
		ies in Beno jue Waves ii	n Evtrucia	<u>"</u> ⊢	Drawing			Calibration				
		ing Sequen		"'	Finish			Sequence			. ,	
		e/Twist in T			Folio	\vdash		P Dimensions				

Page 2

October-23-12	3:14:07 PM	<u> </u>							
Item ID: Revision ID: Item Name:	D412-702-	071 ot Shoulder Harness, 4 po	int	Accept	*N900040	100)* s	Setup Start Stop	14.71
Start Date: Required Date: Reference:	10/23/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:				INIT
Approvals:		lan:		Tooling:	Date:		F	Run Start Stop	"NRT"
Sequence ID/ Work Center I 120 *120* QC Quality Control	D	Operation Description QC4- 100% Inspect kits Memo	for completeness	0.00	Tool ID Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
*130 *130* Packaging Packaging		Packaging Memo Identify and Location: PPP Rev:_	pack for shipping as per	0.00 0.00 PPP D412-702-071	- sol			SL	11/12/29
140 *14 CC QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00 0.00	SEED TO CREATE OUT OF CHE	e003		12	

W 29

										DQA	\: Date	·	
NCR:	es / No				WORK ORDER NON-O		NFOR	MANCE / UP	DATE				,
										QA Close	d: Date	:	
Work Orde	or.				DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS		
Part N					Rework Scrap		1	Skid-tube Machining	Crosstube Small Fab	4	Water Jet od. Eng. Coor.	Engineerin Qualit	y
NCR N	No				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/St	ore/Packaging Supplier	Othe	er
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Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspe	ector
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	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incor	rect	Weld	

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Status

Oty

Issued

Date

Issued

Picklist Print October-23-12 3:14:06 PM 92144 Work Order ID: Parent Item: D412-702-071 **Start Date: 10/23/12** Required Date: 10/23/12 Pilot/Co-pilot Shoulder Harness, 4 point Start Oty: 1.00 **Parent Item Name:** Required Oty: 1.00 Comments: IPP Rev:A 11.03.01 new issue DD verf:EC IPP Rev:B 12.09.05 per DSI9612 DD verf:JFS Oty per Kit Total Component Item ID/ Replacement Mfg/ Last Unit of Oty on Bin Primary Route Item Name Measure Hand Item ID Purch Item Location Location Sea ID Oty Manufactured No 110 Each 2.0000 Shoulder Harness Assembly Location Loc Qty Loc Code fg 2 69330 2 110 584.0000 No Each Purchased Bolt Location Loc Qty Loc Code ST350 584 102832 88 117317 40 120308 80 120770 200 122814 176 AN4'6A No 110 Each 4,857.0000 Purchased Bolt Location Loc Oty Loc Code ST355 4357 122808 357 12324 123248 150

123355 3850 ST356 500 500 121243 No 110 Each 245.0000 Purchased Location Loc Qty Loc Code ST351 245 120873 17 122800 122800 228

										DQA:	Date:	
NCR:	Yes / No				WORK ORDER NON-C	COI	NFORM	MANCE / UPDATE				,
										QA Closed:	Date:	
Work Orde	~~.				DISPOSITION	,		AGA	INST DE	PARTMENT,	/PROCESS	
Work Orde	۲ı		· · · · · · · · · · · · · · · · · · ·		Rework	1		Skid-tube Cross	tube	1	Water Jet] Engineering
Part N	No.				Scrap	┨		Machining Smal	— —	Dro	d. Eng. Coor.	Engineering Quality
raiti	···				Use-as-is	┨		~H	hing	1	e/Packaging	Other
NCR I	No.				Work Order Update	1	1	Large Fab Compo	_	i ilec/stoi	Supplier	
			· · · · · · · · · · · · · · · · · · ·		Tronk Grace Gpaate	.)				j	34ppc.	لــا لـ
Root				Descri	ption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty	c	or Non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
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Material		1										
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Other												
Process												
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Landi	ng Gear				General	_	7			,	_	_
	Bending				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
		lot Conce	ntric to C	D/S	BOM/Route		Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure
<u>'</u>	Cracks				Broken/Damaged		Inspecti	on Incomplete	L	Part Incorre	ct	Weld
		/Crimped			Burrs		4	ions Incomplete/Unclear		Part Lost/M	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance	1	Part Moved		12.

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

· October-23-12 3:14:07 PM

Vork Order ID:	92144										
arent Item:	D412-702-071						Start D	eate: 10/23/12	F	Required Da	te: 10/23/12
arent Item Name:	Pilot/Co-pilot Shoulder H	arness, 4 poi	int				Start (Qty: 1.00		Required Q	ty: 1.00
182104213 lut	Pur	chased	No		110	Each	3,187.0000	6	6 ,	jB	ST P
				Location	Loc Qty		Loc Code			<i>V</i>	,
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	•			Location	Loc Qty		Loc Code			•	,
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			,								DQA:	Date;	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	AANCE / UP	DATE			•
											QA Closed:	Date:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part I	- No					Rework Scrap Use-as-is		Therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR 1	۷o. <u>-</u>					Work Order Update]		Large Fab	Composite	j	Supplier	
Root						ption of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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Supplier													
Training	П												
Unapproved	П		ĺ	İ									
						F	AUI	T CATE	GORY				
Landi	ng G	ear				General		_					
		Bending				Bend	Г	Grain			Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	П	Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/L	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs	•			Contamination		Mainte	nance		Part Moved	<u> </u>	_
	Н	Heat Trea	t			Countersink		Mislabe	eled		Positioned \	Vrong	
	H	Inspection	n Strip in	Tube		Cut Too Short	\vdash	Misread	i		Power Loss/		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

· October-23-12 3:14:07 PM

Vork Order ID: arent Item:	92144 D412-702-071					Start 1	Date: 10/23/12		Required Date: 1	10/23/12
arent Item. arent Item Name:	Pilot/Co-pilot Shoulder Harness, 4 poir	nt					Qty: 1.00		Required Qty:	^
AS1149D0363J /asher	Purchased	No		110	Each	4,800.0000	6	6	18	S
usitoi		L	<u>ocation</u>	Loc Oty		Loc Code				-
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5m/->	•		123355	600						
		S	Т297	2820						
			122378	2820						
		S	T298	111			1223	378		
		J	117601	61				<u> </u>		
			119537	33						
			120308	17						-
AS1149D0432J ASHER	Purchased	No	•	110	Each	113.0000	4	4	~ JB	54
- 0		<u>L</u>	ocation	Loc Oty		Loc Code			<i>V</i>	ŕ
SUP		S	T298	113						
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_			116584	30						(
XS1149D0463J asher	Purchased	No		110	Each	6,768.0000	4	4	-JB	12/11
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$\leq m\Omega$		2	98	165						
3117			122441	165						
		S	T294	5000						
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			104746	1						
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•			122452	1544						
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			121912	38						

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		· . ·								· *	QA	Closed:	Dat	te:	·
Work Ord	ar.					DISPOSITION				AGAINST D	EPAF	RTMENT	PROCESS		
Part I	 No				· · · · · · · · · · · · · · · · · · ·	Rework Scrap Use-as-is		Thern	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR I	No					Work Order Update]		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update		Initial	Ac	tion	S	Sign &	. ·	T	
Cause	-	Date	Step	Qty	,	or Non-conformance	Cr	ief Eng	Desc	ription		Date	Verification	n	QC Inspector
Doc/Data														\exists	
Equip/Tooling															
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Setup										,					
Other															
Process															
Supplier															
Training														- 1	
Unapproved															
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Landi	ng Ge	ear				General		-							
	L	Bending				Bend		Grain			Ov	alized			Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route	L	Hardwa	re	L	Ov	er/Under	tolerance		Temperature/Cure
	\Box	Cracks				Broken/Damaged		Inspecti	on Incomplete		Par	rt Incorre	ct		Weld
		crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear	Par	rt Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination]Mainte	nance		Par	rt Moved			
		leat Trea	t			Countersink		Mislabe	eled	Γ	Pos	sitioned V	Vrong		
		nspection	n Strip in	Tube		Cut Too Short		Misread	d	Γ	Po	wer Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-702-3 REV. A OR EARLIER
AND ICA-D412-702 REV. 4 OR EARLIER

REF CANADIAN STC: SH04-7 REF FAA STC: SR01997NY REF EASA STC: EASA.IM.R.S.00710

1.0 PURPOSE

THE PURPOSE OF THIS DSI IS TO CORRECT THE HARDWARE CALLED OUT IN THE D412-702-071 KIT.

2.0 WEIGHT AND BALANCE

NO CHANGE.

3.0 PARTS LIST

QTY -071	P/N	DESCRIPTION
Х	D412-702-071	DART PILOT/CO-PILOT SHOULDER HARNESS KIT
1	D4305-041	SHOULDER HARNESS .
4	AN3-4A	BOLT
2	AN4-6A	BOLT
2	AN3-10A	BOLT
6	MS21042L3	NUT
2	MS21042L4	NUT
10	NAS1149D0332J	WASHER
6	NAS1149D0363J	WASHER
4	NAS1149D0432J	WASHER
4	NAS1149D0463J	WASHER

IS:

	QTY -071	P/N	DESCRIPTION				
	Χ	D412-702-071	DART PILOT/CO-PILOT SHOULDER HARNESS KIT				
	1	D4305-041	SHOULDER HARNESS				
MAG.	4	AN3-4A	BOLT				
WAS:	2	AN3-6A	BOLT				
	2	AN3-7A	BOLT				
	14	NAS1149D0332J	WASHER				
	8	NAS1149D0363J	WASHER				
	8	MS21042L3	NUT				
	8	MS21042L3	NUT				

MILLON WILL OF 24 | 15-10-54 | UNCONTROL: TO COPY

SHEET 1 OF 2

NTS

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION **BRANCH** DAO # 01-O-01

APPROVED D (DE # 02) D. SHE

DATE: CERT. NO.: ISSUE NO.:

12.05.01 SH04-7

Α	NEW ISSUE	NEW ISSUE			
REV.		DESCRIPTION BY DA			
DESIG	N RP	DART AEROS	DART AEROSPACE LTD		
DRAW	N RP	HAWKESBURY, ON			
CHECKED OF		DRAWING NO.		REV. A	

DSI 9612 MFG. APPR. N/A APPROVED Perf

12:05.01

DE APPR.

DATE

PILOT/CO-PILOT HARNESS SCALE **UPDATES**

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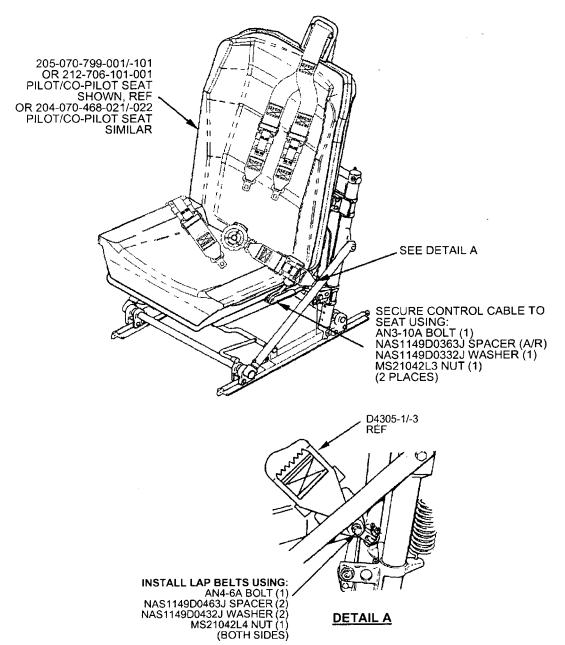
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4.0 CHANGES

FIGURE 2. - DART D412-702-071 LAP BELT INSTALLATION (REF: IIN-D412-702) FIGURE 25.18 DART D412-702-071 PILOT/CO-PILOT SHOULDER HARNESS KIT (REF: ICA D412-702)



DESIGN	RP	DART AEROSPACE LTD
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA
CHECKED	al	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9612 SHEET 2 OF 2
APPROVED	Tup	TITLE PILOT/CO-PILOT HARNESS SCALE
DE APPR.	-##	UPDATES NTS
DATE 12.0	5.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR MY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



IIN-D412-702-3 Page 8 of 8

4.0 WEIGHT AND BALANCE

		LA	FERAL	LONGITUDINAL	
Installation	Weight	Arm	Moment	Arm	Moment
D412-702-071, Pilot/Co-pilot Shoulder	-2.6 lb -1.2 kg	+/- 22.0 in +/- 0.56 m	-/+ 57.2 in lb -/+ 0.67 m kg	47.0 in 1.19 m	-122.2 in lb -1.43 m kg

5.0 PARTS LISTS

QTY -071	Part Number	Description
Х	D412-702-071	Dart Pilot/Co-Pilot Shoulder Harness Kit
1	D4305-041	SHOULDER HARNESS
4	AN3-4A	BOLT
2	AN3-6A	BOLT
2	AN3-7A	BOLT
14	NAS1149D0332J	WASHER
8	NAS1149D0363J	WASHER
8	MS21042L3	NUT

Revision: A
Date: 10.12.01

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-702-3 REV. A OR EARLIER AND ICA-D412-702 REV. 4 OR EARLIER

REF CANADIAN STC: SH04-7 REF FAA STC: SR01997NY REF EASA STC: EASA.IM.R.S.00710

1.0 PURPOSE

THE PURPOSE OF THIS DSI IS TO CORRECT THE HARDWARE CALLED OUT IN THE D412-702-071 KIT.

2.0 WEIGHT AND BALANCE

NO CHANGE.

3.0 PARTS LIST

[Q	TY)	P/N	DESCRIPTION
	X)	D412-702-071	DART PILOT/CO-PILOT SHOULDER HARNESS KIT
	4===	=D4305=041=	SHOULDER HARNESS
<u> </u>	4=	AN3-4A	BOLT
	2===	AN4-6A	BOLT
E	2=	-AN3-10A	-BOLT
•		*M\$21042L3	=NUT
		11.02.4.9	NUT
		=NAS1149D0332J===================================	=WASHER>
			WASHER>
		NAS(149D0463J====	:WASHER

	QTY -071	PYU	DESCRIPTION			
	_ X /	D412-702-071	DART PILOT/CO-PILOT SHOULDER HARNESS KIT			
WAS:	معاسر	D4305-0417	SHOULDER HAPNESS			
	=2_	AN3-6A	BOL			
	2	AN3-7A	BOLT			
	14	NAS1149D0332J	WASHER			
	8	NAS1149D0363J	WASHER			
	8	MS21042L3	NUT			

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

BY: D. SHEPHERD (DE # 02)

DATE: 12.05.01 CERT. NO.: SH04-7 ISSUE NO.: 3

A	NEW IS	NEW ISSUE			12.05.01			
REV.			BY	DATE				
DESIG	N	RP	DART AEROSPACE LTD					
DRAW	N	RP	HAWKESBURY, ONTARIO, CANADA					
CHECKED		al	DRAWING NO.		REV. A			
MFG. A	MFG, APPR.		DSI 9612		SHEET 1 OF 2			
APPRO	APPROVED /WP.		TITLE PILOT/CO-PILO		ESS SCALE			
DE API	DE APPR.		UPDAT		NTS			
DATE 12.05.01			COPYRIGHT © 2012 BY DA THIS DOCUMENT IS PRIVATE AND CONFIDERTIVE AND IS SU NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COM WATTEN PERMISSION FROM DA	MUNICATED TO ANY OT	S COMPINION INVITED			

Change Record

PAGE 1 OF

Part Number:

D412-702-071

Description:

PILOT/CO-PILOT SHOULDER HARNESS

CHG#	DATE	BY	RELEVANT DOCUMENTS	ECN#
001	11.02.28	KJ	MDL-D412-702 REV. O	11-526
002	12.05.28	KJ	D4305 REV. B	12-587
003	12.07.25	KJ	DSI 9612 REV. A, D4305 REV. C	12-595

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